Date: Wednesday, 12/20/2006 11:58:59 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: JET
Job Number	: 29990		
Estimate Number	: 10583		
P.O. Number	: N/A	**Part Number**	: D2003077
This Issue	: 12/20/2006 **S.O. No.** : N/A	**Drawing Number**	: ~~UNDER REVIEW~~ GB 06.12.20
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : SMALL /MED FAB	**Drawing Revision**	: A
Previous Run	: 29928A	**Material**	: N/A
Written By	:	**Due Date**	: 1/15/2007 **Qty:** 11 **Um:** Each
Checked & Approved By	: 06 12.20		
Comment	: Est: A 04.05.17 New issue KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0375W035	6061-T6 Tube .375 x.035W

Comment: Qty.: 1.0625 f(s)/Unit Total : 11.6875 f(s)
6061-T6 Tube .375 x.035W
Material: 6061-T6 tubing 0.375OD x 0.035" wall
(M6061T6T0.375W.035) Batch: M17931 ~~XXXXXX~~ 8.5(sf) MF 07-01-08. M19051 x3,1875(sf)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Cut (2) D2003-077 blanks per (1) DSI 9051 Kit
2- Cut blanks: 6.250" long as per template D2003-077
3- Form, drill & ~~XXXX~~ as per template D2003-077
Identify for D2003-077
MF. 07-01-09 (P10)

3.0	516IN200	Set Screw

Comment: Qty.: 2.0000 Each(s)/Unit Total : 22.0000 Each(s)
Set Screw
Pick:

Qty	Part Number	Description	Batch
2	5/16"-18 NC -.200	Set Screw	M19473

MF. 07-01-09

4.0	AN8186D	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 22.0000 Each(s)
Nut
Pick:

Qty	Part Number	Description	Batch
2	AN818-6D	Nut	M17651

MF. 07-01-09

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WORK ORDER CHANGES

W/O:

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-01-08	2.0	Remove flare. And put at step 6.0 at assembly, After putting on the sleeve. Perm. Change	MF.	07-01-09	11	07-01-08 QS1042.	07-01-08
07-01-09	6.0	Applied loctite 262 threadlocker. ~~B~~ M102963 on each screw. ADD TO step 6.0 perm. change	MF.	07-01-09	11	07-01-15 QS1042	07-01-15

Part No: B2003-077 PAR #: _____ Fault Category: Prod/Engineering (cordinator) NCR: (Yes) No DQA: ~~No~~ Date: 07/01/31

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR: 29990

DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
07-01-08	2.0	W/O instructions were wrong. Flare was made before the hardware was picked, and the sleeve was installed.	QS1042.	grind off the flare as necessary to install MS20819-6D sleeve. Then flare.	MF. 07-01-09.	07-01-15	QS1042	07-01-08

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 11:58:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** JET

Job Number: 29990 **Part Number:** D2003077

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	MS208196D	Sleeve

Comment: Qty.: 2.0000 Each(s)/Unit Total : 22.0000 Each(s)
Sleeve
Pick:

Qty	Part Number	Description	Batch
2	MS20819-6D	Sleeve	M17054 ~~X2[illegible]~~ ~~M17054X1[illegible]~~

MF. 07-01-09.

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2003
Identify as D2003-077

MF. 07-01-09

7.0	QC5	INSPECT WORK TO CURRENT STEP

07.01.15

Comment: INSPECT WORK TO CURRENT STEP

8.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____

07/01/30

9.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

07/01/31

Job Completion

M 07.01.31

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2003 — REV. B — SHEET 1 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES — SCALE NTS

A	90.04.09	NEW ISSUE
B	99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)

RELEASED 99.06.08 KE

NOTE: FLAT LENGTHS MAYBE INCORRECT. BEND TO BENT TOOL. REPORT TO ENGINEERING

UNDER REVIEW CB 06.12.13 some flat lengths wrong
CC.08.21 CB

SHOP COPY
RETURN TO ENGINEERING

WORK ORDER NO. 29990

P/N	TEMPLATE	HEATSLEEVE LENGTH[1]	CUT LENGTH OF TUBE[2]	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL[4/6/7]	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25					1	1	JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2003	REV. B SHEET 2 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES	SCALE NTS

ISSUED OA COPY

RELEASED
99.06.04 KE

UNDER REVIEW
06.08.21 CB
Some Flat lengths wrong
CB 06.12.13

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. ~~135~~ 29990

Notes:

(1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.

(2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.

(3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.

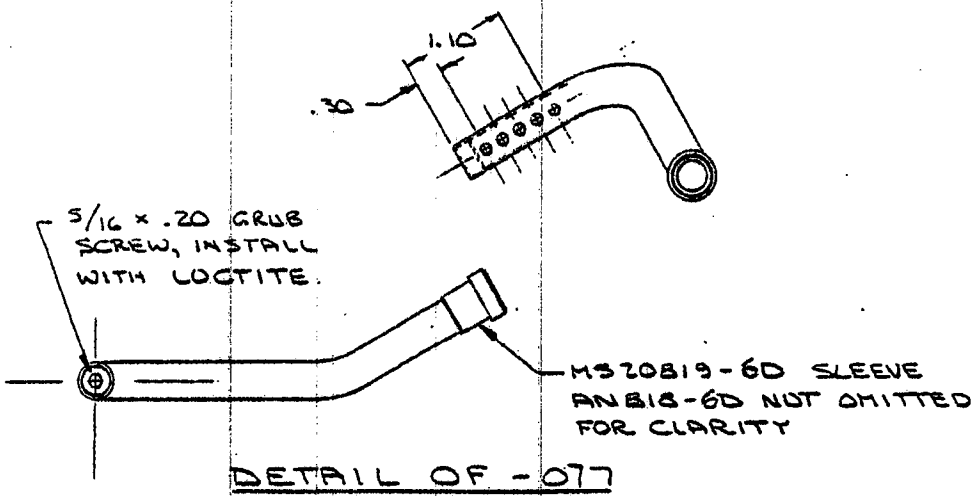
(4) ENSURE SEAMLESS TUBING IS USED.

(5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.

(6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.

(7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.

(8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



DETAIL OF -077